

Work Order ID 68465

Page 1

Wednesday, April 13, 2011 4:14:54 PM

Item ID: D3443-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Weldment Assembly

Start Date: 4/13/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3443

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3443

PD 11-04-15 ③

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

QC 11-04-18 ③

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 w/04/18

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
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Run Hours

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Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

M116964

Memo

0.00

Powder Coating

Mask holes as per dwg D3443

START TIME: 1:00pm

OVEN TEMPERATURE: 400°

FINISH TIME: 1:30pm

3 0 All 4/13/11

140



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

M 11 04 19 (3)

150



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

S 11/04/20 (3)

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Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



0.00 5/16/20

QC

Memo

Quality Control



170

Identify as per dwg & Stock Location: 198A

0.00



0.00

Packaging

Memo

Packaging

11/4/21 (32) [Signature]

180

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

11/4/21 [Signature]

ME
11-04-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 13, 2011 4:14:59 PM

Page 1

Work Order ID: 68465

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly



Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3443-1 Lug		Manufactured	No			100	Each	3.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				3					
					58562			3					
D3443-5 Tubing		Manufactured	No			100	Each	4.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				4					
					60230			4					
D3453-1 Clevis		Manufactured	No			100	Each	7.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				7					
					58564			1					
					59449			6					
D3965-4 Bearing, Spherical		Manufactured	No			100	Each	7.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST100				7					
					60479			7					



PD 11-04-15



PD 11-04-15



PD 11-04-15



4/14/11

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 13, 2011 4:14:59 PM

Page 2

Work Order ID: 68465

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly



Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 3.00

Required Qty: 3.00

D3966-4-750

Manufactured No

100 Each

55.0000

2

6



Pin, Dowel



PD 11-04-15

Location

Loc Qty

Loc Code

ST100

55

58711

55



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

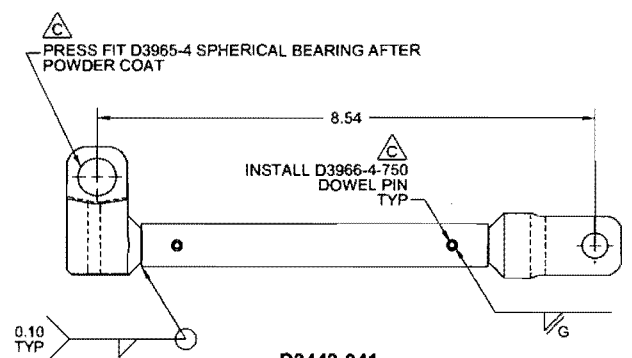
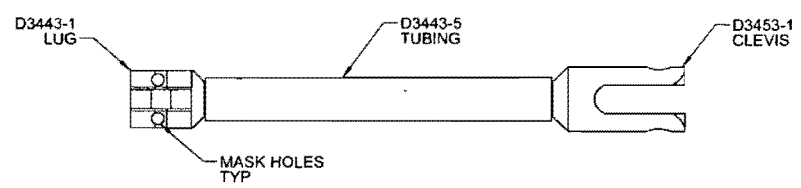
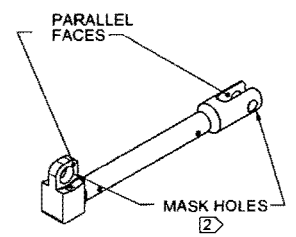
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8 7 6 5 4 3 2 1



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68465

11-01-13

RELEASED
07/08/25/11

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0 219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENBUR P/N (ZN C8-1, B5-2); D3966-4-750 WAS MCMMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

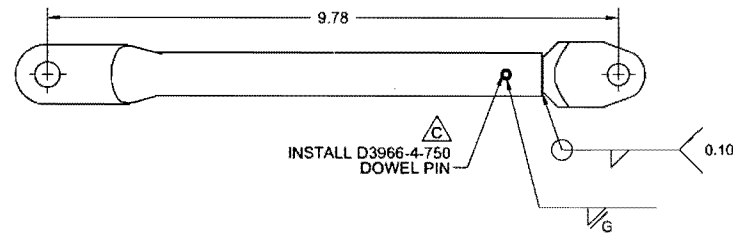
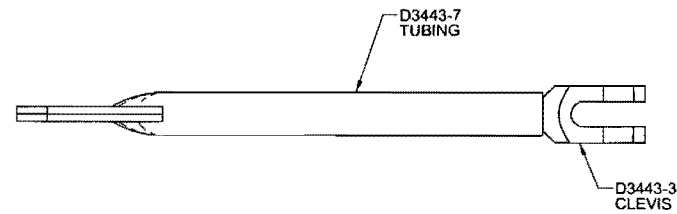
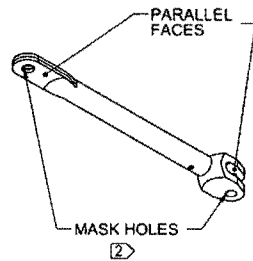
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

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CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 2 OF 4
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09/06/25

21068945

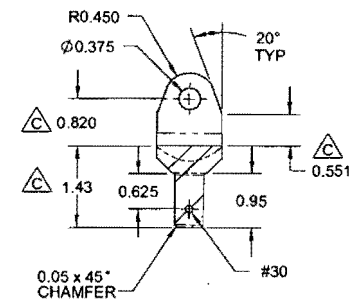
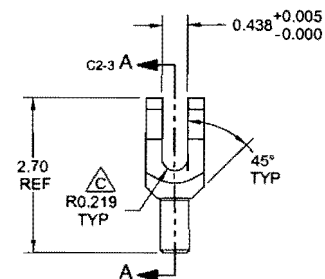
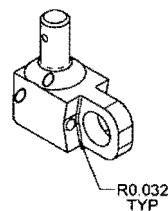
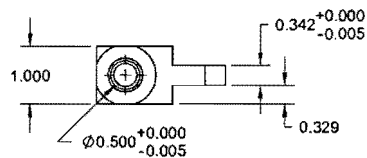
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

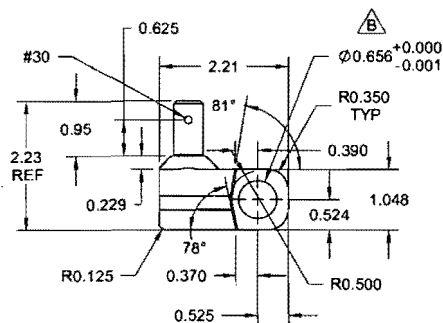
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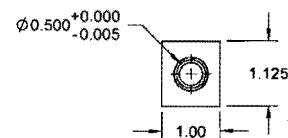
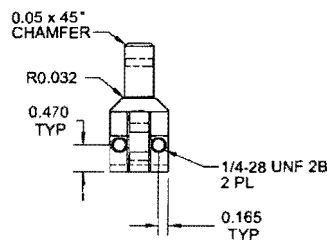
NOTE: Date & initial all entries



SECTION A-A C4-3



D3443-1 LUG



D3443-3 CLEVIS

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

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MFG. APPR.		D3443	SHEET 3 OF 4
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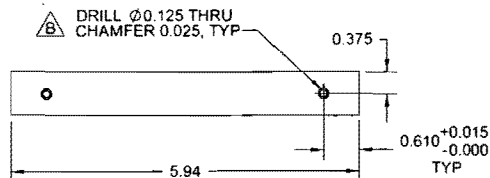
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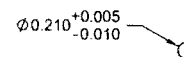
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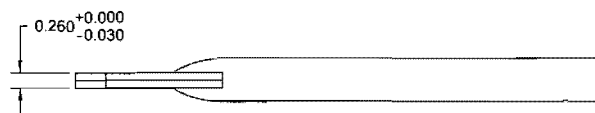
D3443-5 TUBING



D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

W/O 68445

RELEASED
01/28/25 MP

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MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
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